

Date: Thursday, 02/04/2009 2:25:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW ASSEMBLY		
Job Number	: 46851			Part Number	: D3136041		
Estimate Number	: 10758			Drawing Number	: D3136 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/04/2009	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 20/04/2009	Qty:	6
Previous Run	: 44297			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 09 04.02</u>						
Comment	: Est B 04.02.04 Rerformat KJ/DS						
	: Est C Thermoform in house 05/07/2007 DL						
	: Est D Rev E 07.09.28 EC verified by: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet
Comment: Qty.: 4.4625 sf(s)/Unit Total : 26.7750 sf(s) polycast II or plexiglass G .125" <u>110633</u> <u>HR 9-4-15</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET <u>E</u> <u>EE</u> <u>HR 9-4-15</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>HR 9-4-15</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>5 09/04/15</u> <u>(X6)</u>		
Comment: SECOND CHECK		
5.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: 1-Thermoform as per Dwg D3136 and Folio FTA006 Dwg Rev. <u>E</u> Folio Rev. <u>B.</u>		
<u>BB 09/04/2009 X6</u>		
2- Engrave Part # and Batch #, and affix labels (D3136-1)		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:25:55 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 46851

Part Number: D3136041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



P.T.O.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances.

BB 09/04/20 (X5)

7.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Sat 09/04/20 (X5)

8.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

BB 09/04/20 (X5)

9.0 D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
2	D3108-9	Decal	B 34554

BB 09/04/20 (X5)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sat 09/04/20 (X5)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 80215

10/9/27 (5)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27 (5)

Job Completion



MF
09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/04/22

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 46851		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/22	6.2	Notes on lower left window not cut PC machine malfunction Date set	QSIU12	Scrap & destroy QTY 1 window. All remaining parts are good.	09/04/22	09/04/22	QSIU12	09/04/22

NOTE: Date & initial all entries

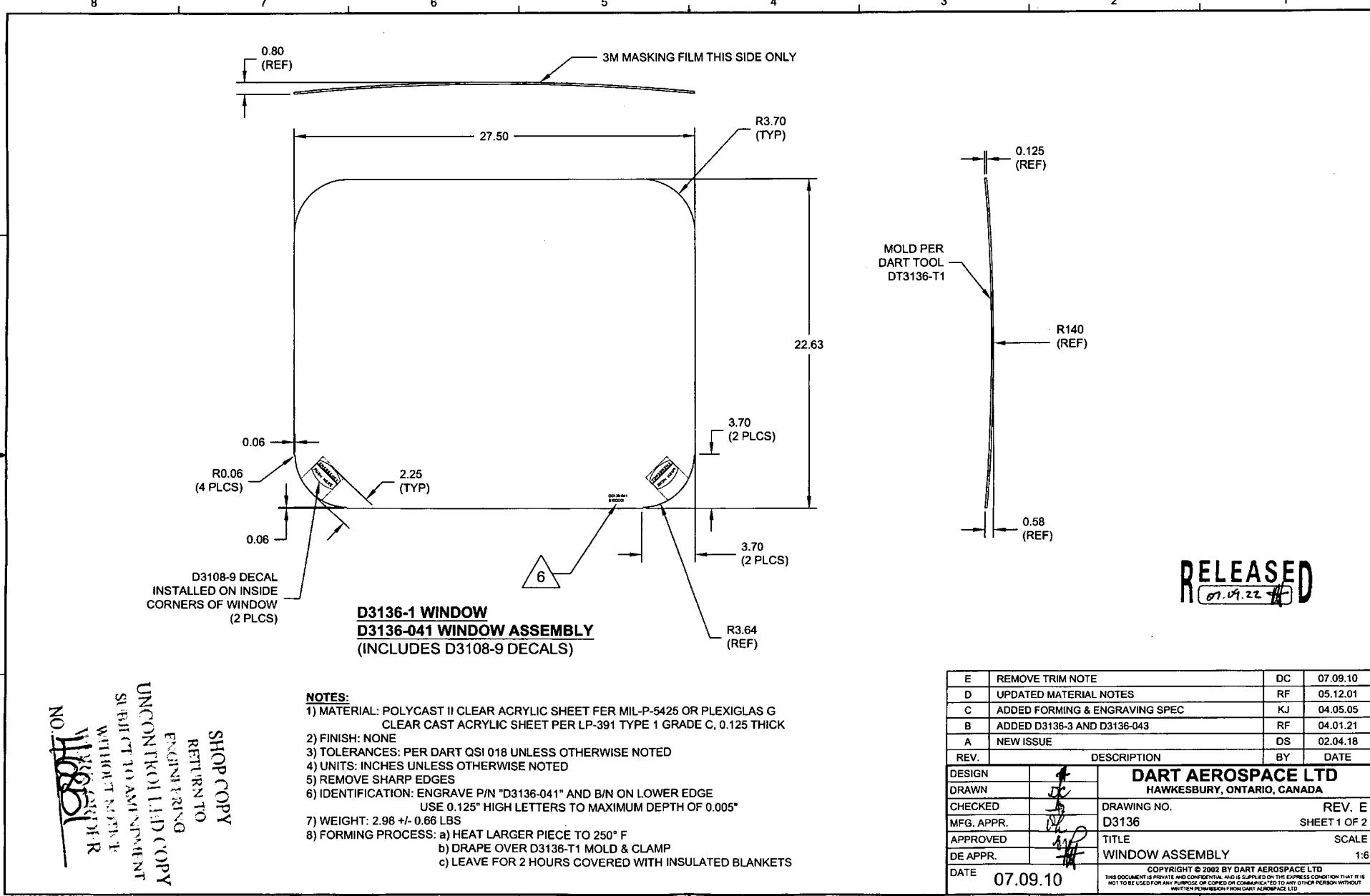
DART AEROSPACE LTD	Work Order:	46851
Description: WINDOW	Part Number:	D3136-1
Inspection Dwg: D3136-1 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: HB	Audited by: S	Prototype Approval: <input checked="" type="checkbox"/>
Date: 9-4-15	Date: 09/04/15	Date: <input checked="" type="checkbox"/>

Rev	Date	Change	Revised by	Approved
A	..	New Issue	KJ/JLM	



E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	PL	D3136	SHEET 1 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	12	WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS FOR INTERNAL USE ONLY AND IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

